



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-100
Job Sheet 179646



Part No: SWA25A-100

Job Qty: 7 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA25A-100 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	7 Ea		7/6/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	7 pcs		7/6/18	0.00	7.00	MORI NLX		
120	QC	7 pcs		7/6/18	0.00	0.00	QC2		
130	QC	7 pcs		7/6/18	0.00	0.00	QC8		
140	Packaging	7 pcs		7/6/18	0.00	0.00	Packaging3		
150	QC21-SA	7 Ea		7/6/18	0.00	0.00	QC21		

Part Op 110 - Cut Blanks AT 7.00" 1-Machine as per DWG. FB901 FOLIO REV: AA DWG REV: 6
Descriptions: 2-Deburr 3-2-***Please see PEC to change engraving batch # for every w/o***

DAG
21 JUL 25 2018
9:09

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.000	17-4 H1150 Round Bar 3.000"	4.0810 ft (.583 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R3.000	4	1	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 1:41 PM Dart.lajeunesse.marie

6-11 AM
1807-17

12 hrs total



Container No: S091346



Part: SWA25A-100

Job No: 179646

Serial No/Batch: S091346

Revision: 6

Inspector:

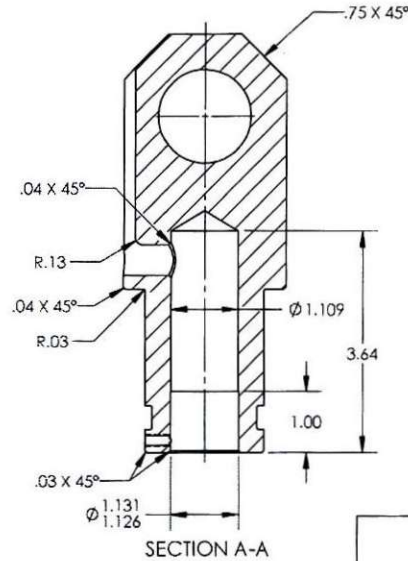
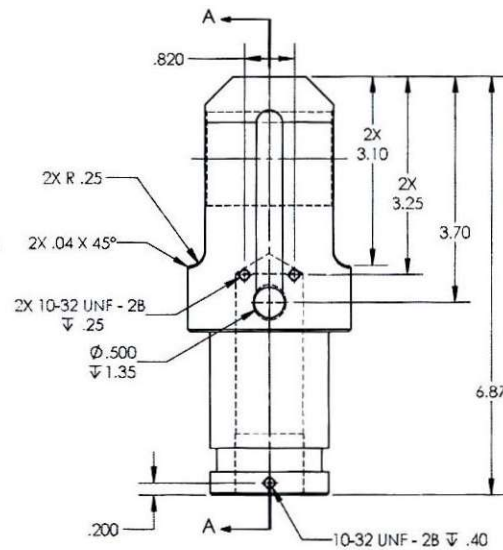
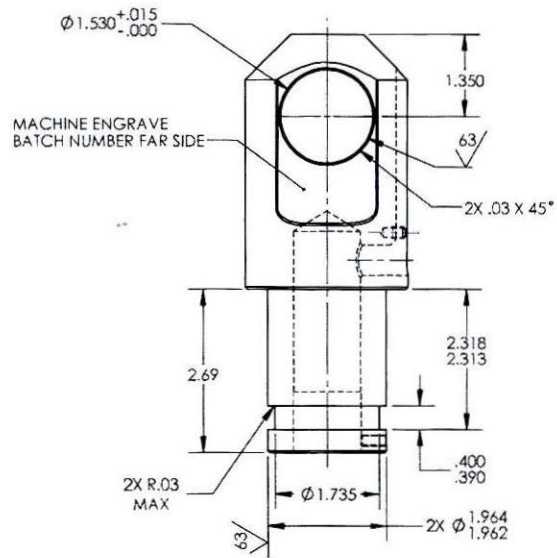
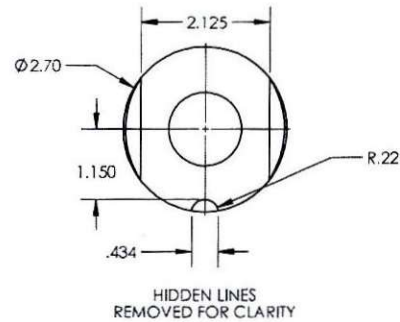
Exp Date:

Instructions:

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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/12/18

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM.	11/12/2012	JAG	
5A		CHD B/O TO SWA25A-100 BLANK	5/1/2014	JAG	RW
6	16-0275	UPDATED TO NEW STANDARDS. ADDED NOTE "ENGRAVE BATCH NUMBER". CHD MATL WAS SS 17-4 H1150 E 25 17-4 H1150/H1075. CHD DIM WAS 3.100 B 2X 1.10. ADDED DIM 2.69. 2X.03 MAX. Ø1.735. 2.318/Ø.115. .400/.390. 2X Ø1.964/1.962. .04 X 45°. R.03. .03 X 45°. Ø1.131/1.126. 1.00. Ø1.109. 3.64. Ø2.70. 75 X 45° REMOVED DIM 1.370.	12/29/2016	SM	JAG

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OF SPECIFICATIONS
			SWA25A-100	1	LOWER END	SS 17-4 H1150/17-4 H1075	

DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA25A-100	REV 6
MAYL SS 17-4 H1150/17-4 H1075	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
FRAT XXX ± .005	FRACTIONS ± 1/8
FINISH XX ± .01	ANGLES 9-15°
SPEC X ± .1	SURFACES = 125
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
DRAWN BY: CANAM	
CHECKED: CLOUGH	
DPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 1/22/2002
SHEET 1 OF 1	

DART AEROSPACE LTD		Work Order: 1796416
Description: Lower End		Part Number: 102-578
Inspection Dwg: SWA25A-100 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	±.015 (-.02)	1.534	✓		Mic LPO5	
1.350	±.005	1.348	✓		H.G.	
.03x45°	±.010 x.5°	.032x45	✓		Vern LPO9	
2.69	±.01	2.685	✓		↓	
1.735	±.005	1.735	✓		↓	
1.963	±.001	1.963	✓		Mic LPO2	
.395	±.005	.395	✓		↓	
2.3155	±.0025	2.314	✓		H.G.	
Ø2.70	±.01	2.700	✓		Vern LPO9	
2.125	±.005	2.125	✓		↓	
.434	±.005	.438	✓		↓	
R.22	±.01	.219	✓		↓	
R.25	±.01	.250	✓		↓	
.820	±.005	.821	✓		↓	
.04x45°	±.01 x.5°	.03x45	✓		Vern LPO9	
10-32unF-2B	GO-NOT GO	GO	✓		↓	
.25	±.01	.25	✓		↓	
Ø.500	±.005	.500	✓		↓	
1.35	±.01	1.35	✓		↓	
.200	±.005	.200	✓		↓	
3.10	±.01	3.0975	✓		H.G.	
3.25	±.01	3.249	✓		↓	
3.70	±.01	3.703	✓		↓	
6.87	±.01	6.872	✓		Vern LPO	
R.13	±.01	.125	✓		↓	
.04x45°	±.01 x.5°	.04x45	✓		↓	
R.03	±.01	.032	✓		↓	
.03x45°	±.01 x.5°	.032x45	✓		↓	

Measured by: P	Checked by: B	QC Inspector:
Date: 18-07-23	Date: 18-07-24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

